

**Work Order ID 64097**

Wednesday, November 24, 2010 8:52:57 AM



Page 1

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 11/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

*PL*Date: 10/24 Tooling:

Date:

Run Start



QC:

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3584	Rev A

100 0.00

Skidtubes

Skidtubes

Memo

Skidtubes

- 1-Cut to Length as per Dwg D3584
- 2-Drill Pillot Holes using DT8960 Drill Jig
- 3-Open pilots to 1.000" as per Dwg D3584
- 4-Deburr

110 0.00

QC5- Inspect part completeness to step on W/O

QC

Memo

Quality Control

120 0.00

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

Hand Finishing

*2 0 8E10/12**DP 10-12-6 ②**DP 10-12-6 ②*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 64097**

Wednesday, November 24, 2010 8:52:57 AM



Page 2

Item ID: D3584-1

Accept



Setup Start



Revision ID:

Item Name: Web

Stop



Start Date: 11/24/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

2 0 10/12/07

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 4/6

0.00

DD

10-12-7

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/07 HJ

MW  
10-12-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Wednesday, November 24, 2010 8:53:01 AM

Work Order ID: 64097



Parent Item: D3584-1



Parent Item Name: Web

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2963-125		Manufactured	No			110	Each	119.0000	1	2			

105 I Beam Extrusion

Location	Loc Qty	Loc Code
HALL	119	
27775	4	
28673	115	

2 BE 10/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

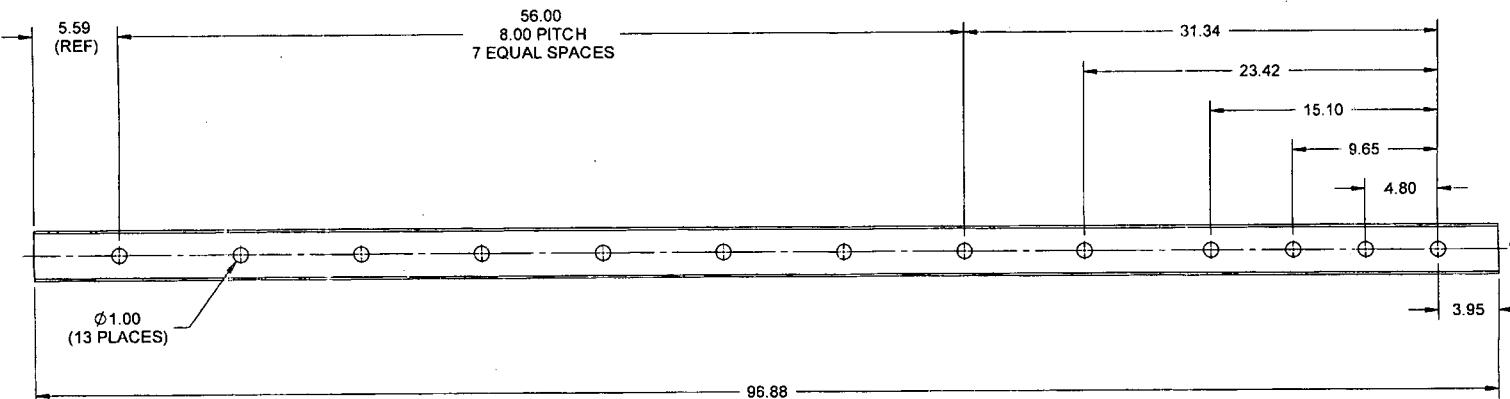
NO. 051097

07/11/24

8 7 6 5 4 3

D

D



D3584-1 WEB

B

B

A

A

NOTES

- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.08 lbs

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PF	DART AEROSPACE USA, INC.	
DRAWN	PF	PORT HADLOCK, WA	
CHECKED	PF	DRAWING NO.	REV. A
MFG. APPR.	PF	D3584	SHEET 1 OF 1
APPROVED	PF	TITLE	SCALE
DE APPR.	PF	WEB	1:8
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8

7

6

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